

Work Order ID 55010

January 5, 2010 12:44:51 PM

Page 1

Item ID: D3490-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Cross Bolt Spacer

Start Date: 05/01/2010 Start Qty: 60.00

Cust Item ID:

Required Date: 15/01/2010 Req'd Qty: 60.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date: 10-1-05 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3490

Rev A

100

0.00

10.10.20



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-TURN AS PER FOLIO FA629 & DWG D3490 FOLIO REV AA DWG
REV: 2-DEBURR AS REQUIRED

110

0.00

10.10.20



QC2- Inspect parts off machine FA1/FA1B

QC

Memo

0.00

Quality Control

60 4

120

0.00

10/01/22



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

60 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: LG

0.00



Packaging

Memo

Barthay

0.00

Packaging

10-1-22 (60x) SP

140

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/2548
MF 10-1-22

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 55010



Parent Item: D3490-3



Parent Item Name: Cross Bolt Spacer

Start Date: 05/01/2010

Required Date: 15/01/2010

Comments:

Start Qty: 60.00

Required Qty: 60.00

Component ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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M6061T6R0.750

Purchased

No

100

f

82.7864

16.8000



6061-T6 Round Bar .750"

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

82.7864

110791

2.97

112041

2.3164

112442

50

112663 ✓

27.5

10-10-20

16'

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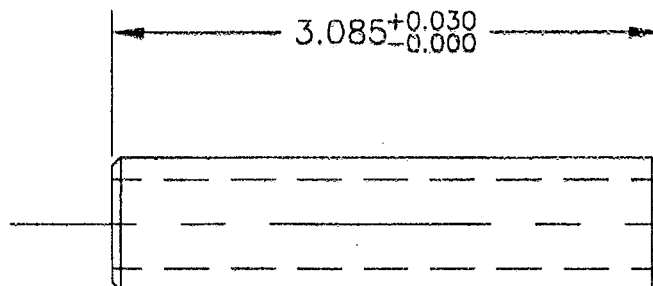
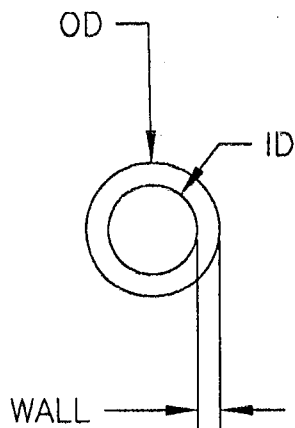
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DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3490	REV. A SHEET 1 OF 1
DATE 06.01.04		TITLE CROSS BOLT SPACER	SCALE NTS
A	06.01.04	NEW ISSUE	



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *55010*

0.050 X 45°
CHAMFER (TYP)

D3490-1/-3/-5 CROSS BOLT SPACER PARTS LIST

PART NUMBER	OD	WALL	ID (REF)	MATERIAL SPEC
D3490-1	0.500	0.049	0.402	M6061T6T0.500W.049
D3490-3	0.750	0.080	0.591	M6061T6R0.750
D3490-5	0.313	0.058	0.197	M6061T6T0.313W.058

D3490-1/-3/-5 CROSS BOLT SPACER

- 1) MATERIAL: ALUMINUM 6061-T6 (QQ-A-200/8 OR QQ-A-225/8)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
06-02-07

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